



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
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**D3492-3****Job Sheet 191067**

Part No: D3492-3

Job Qty: 60 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

**Bill of Materials****Job Routing**

| Op No | Operation                     | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off |
|-------|-------------------------------|--------|------------|----------|-----------|---------|--------------------------|-----------|----------|
|       |                               |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |          |
| 100   | Hardinge - 1                  | 60 pcs |            | 3/18/19  | 0.00      | 2.25    | Hardinge - 1             |           |          |
| 120   | QC 8                          | 60 pcs |            | 3/18/19  | 0.00      | 0.00    | QC 8 - 12                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 14                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 17                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 20                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 25                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 3                 |           |          |
|       |                               |        |            |          |           |         | QC 8 - 32                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 33                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 35                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 39                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 4                 |           |          |
|       |                               |        |            |          |           |         | QC 8 - 44                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 45                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 49                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 58                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 8                 |           |          |
|       |                               |        |            |          |           |         | QC 8 - 9                 |           |          |
|       |                               |        |            |          |           |         | QC 8 - 68                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 67                |           |          |
|       |                               |        |            |          |           |         | QC 8 - 1 (A)             |           |          |
|       |                               |        |            |          |           |         | QC 8 - 47                |           |          |
| 130   | Handfinish - 1-1 Chemical-B4B | 60 pcs |            | 3/18/19  | 0.00      | 0.21    | Handfinish - 1 - 1 - B4B |           |          |
|       |                               |        |            |          |           |         | Handfinish - 1 - 2 - B4B |           |          |
|       |                               |        |            |          |           |         | Handfinish - 1 - 3 - B4B |           |          |
|       |                               |        |            |          |           |         | Handfinish - 1 - 4 - B4B |           |          |
|       |                               |        |            |          |           |         | Handfinish - 1 - 5 -     |           |          |



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Container No: S163290



Part: D3492-3

Job No: 191067

Serial No/Batch: S163290

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/18/19

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|                                     |        |         |           |                           |              |
|-------------------------------------|--------|---------|-----------|---------------------------|--------------|
|                                     |        |         |           | B4B                       |              |
|                                     |        |         |           | Handfinish - 1 - 6 - B4B  |              |
|                                     |        |         |           | Handfinish - 1 - 7 - B4B  |              |
|                                     |        |         |           | Handfinish - 1 - 8 - B4B  |              |
|                                     |        |         |           | Handfinish - 1 - 9 - B4B  |              |
|                                     |        |         |           | Handfinish - 1 - 10 - B4B | D.R 19/03/18 |
|                                     |        |         |           | Handfinish - 1 - 11 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 12 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 13 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 14 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 15 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 16 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 17 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 18 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 19 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 20 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 21 - B4B |              |
|                                     |        |         |           | Handfinish - 1 - 22 - B4B |              |
| 140 Powdercoat - 1 White Gl(A)- B4B | 60 pcs | 3/18/19 | 0.00 0.12 | Powdercoat - 1 - B4B      |              |
|                                     |        |         |           | Powdercoat - 2 - B4B      |              |
|                                     |        |         |           | Powdercoat - 3 - B4B      |              |
|                                     |        |         |           | Powdercoat - 4 - B4B      |              |
|                                     |        |         |           | QC 3 - 10                 |              |
|                                     |        |         |           | QC 3 - 13                 |              |
|                                     |        |         |           | QC 3 - 15                 |              |
|                                     |        |         |           | QC 3 - 17                 |              |
|                                     |        |         |           | QC 3 - 18                 |              |
|                                     |        |         |           | QC 3 - 2                  |              |
|                                     |        |         |           | QC 3 - 26                 |              |
|                                     |        |         |           | QC 3 - 28                 |              |
|                                     |        |         |           | QC 3 - 3                  |              |
|                                     |        |         |           | QC 3 - 30                 |              |
|                                     |        |         |           | QC 3 - 34                 |              |
|                                     |        |         |           | QC 3 - 36                 |              |
|                                     |        |         |           | QC 3 - 41                 |              |
|                                     |        |         |           | QC 3 - 51                 |              |
|                                     |        |         |           | QC 3 - 58                 |              |
|                                     |        |         |           | QC 3 - 59                 |              |
|                                     |        |         |           | QC 3 - 6                  |              |
|                                     |        |         |           | QC 3 - 68                 |              |
|                                     |        |         |           | QC 3 - 9                  |              |
| 150 QC 3                            | 60 pcs | 3/18/19 | 0.00 0.00 | Packaging 3 - 1 - B4B     |              |
|                                     |        |         |           | Packaging 3 - 2 - B4B     |              |
|                                     |        |         |           | Packaging 3 - 3 - B4B     |              |
|                                     |        |         |           | Packaging 3 - 4 - B4B     |              |
| 160 Packaging 3-1 - Stock - B4B     | 60 pcs | 3/18/19 | 0.00 0.00 |                           |              |

|  |  |  |  |                        |           |         |           |                 |                   |
|--|--|--|--|------------------------|-----------|---------|-----------|-----------------|-------------------|
|  |  |  |  | Packaging 3 - 5 - B4B  |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 6 - B4B  |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 7 - B4B  | DA        |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 8 - B4B  | 2         |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 9 - B4B  | 9-89      |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 10 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 11 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 12 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 13 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 14 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 15 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 16 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 17 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 18 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 19 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 20 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 21 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 22 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 23 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 24 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 25 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 26 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 27 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 28 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 29 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 30 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 31 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 32 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 33 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 34 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 35 - B4B |           |         |           |                 |                   |
|  |  |  |  | Packaging 3 - 36 - B4B |           |         |           |                 |                   |
|  |  |  |  | 170 QC 21 - SA         | 60<br>pcs | 3/18/19 | 0.00 0.00 | QC 21 - SA - 21 |                   |
|  |  |  |  |                        |           |         |           | QC 21 - SA - 70 | DA 21 MAR 27 2019 |
|  |  |  |  |                        |           |         |           | QC 21 - SA - 53 | 9-89              |

Part Op 100 - (Hardinge) 1-Turn as per Folio FA632 & Dwg D3492  
 Descriptions: 120 - (QC8- Inspect parts - second check)  
 130 - (Chemical Conversion Coat per QSI005 4.1)  
 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only)  
 150 - (QC3- Inspect Part Finish)  
 160 - (Identify as per dwg & Stock Location: \_\_\_\_\_) LOCATION : FP001  
 170 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item   | Component Name          | Quantity            | Operation        | Container |
|---------------|-------------------------|---------------------|------------------|-----------|
| M6061T6R0.750 | 6061-T6 Round Bar .750" | 3.5400 ft (0.59 ea) | 100-Hardinge - 1 | 8/10759   |

## Job Allocations

| Operation        | Component Part | Required | Inventory | Allocated |
|------------------|----------------|----------|-----------|-----------|
| 100-Hardinge - 1 | M6061T6R0.750  | 4        | 24        | 0         |



| Part Specifications |             |                                |                |        |                  |
|---------------------|-------------|--------------------------------|----------------|--------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits         | Type   | Special Comments |
| 1                   | Plug        | 0.750inches $\pm$ 0.010        | 0.760<br>0.740 | 792    |                  |
| 2                   | Plug        | 0.582inches + 0.000<br>- 0.002 | 0.582<br>0.580 | 25825X |                  |
| 3                   | Plug        | 0.045inches + 0.000<br>- 0.002 | 0.045<br>0.043 | 20444  |                  |
| 4                   | Plug        | 0.060inches $\pm$ 0.005        | 0.065<br>0.055 | 20605  |                  |
| 5                   | Plug        | 0.060inches $\pm$ 0.005        | 0.065<br>0.055 | 206    |                  |
| 6                   | Plug        | 0.500inches $\pm$ 0.010        | 0.510<br>0.490 | 2500   |                  |
| 7                   | Plug        | 0.090inches + 0.000<br>- 0.002 | 0.090<br>0.088 | 2089   |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------|------------------------|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |              |                        |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042) |                        |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |              | Completed By           |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              | Lead hand / Supervisor |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              | QC / QA Coordinator    |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |              |                        |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |              |                        |